

Work Order ID 58832

Wednesday, May 19, 2010 1:07:41 PM



Page 1

Item ID: D3641-3

Accept



Setup Start



Revision ID:

Item Name: Cover

Stop



Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date: 10-5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3641

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

10-6-2

FLOW CNC Waterjet

5052.030

1-Cut as per Dwg D3641

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

⑦

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

10-6-2

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

5060603

④7

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 58832

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Page 2

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Setup Start



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Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3641-3

0.00

0.00

Sb 10/06/18

7

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/06/18

7

-3

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

ml 10 06 21 7

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 58832

Wednesday, May 19, 2010 1:07:41 PM



Page 3

Item ID: D3641-3

Accept



Setup Start



Revision ID:

Item Name: Cover

Stop



Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7

10-6-22

170

Identify as per dwg & Stock Location: 57260 0.00



Packaging

Memo

0.00

Packaging

10/6/22 (7)

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/06/23

10.06.22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:07:45 PM

Page 1

Work Order ID: 58832



Parent Item: D3641-3



Parent Item Name: Cover

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M5052H32S.032 | | Purchased | No | | | 100 | sf | 67.5000 | 0.7851 | 5.5 | | |
| | | | | | | | | | | | B 10-6-2 | |

5052-H32 .032 Sheet

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT23 | 67.5 | |
| 100470 | 3 | |
| 103321 | 3 | |
| 105998 | 7 | |
| 108462 | 10 | |
| 109478 | 9 | |
| 111448 | 3 | |
| 112664 | 29.5 | |
| 15031 | 3 | |

112664

⑦

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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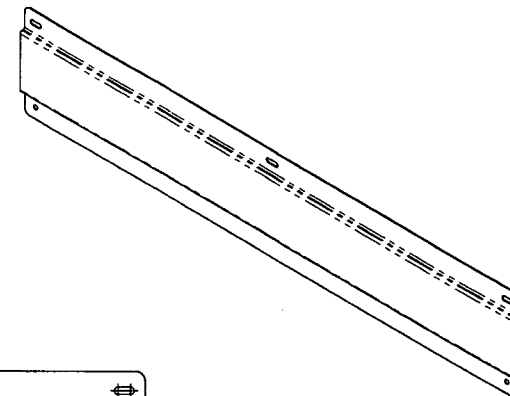
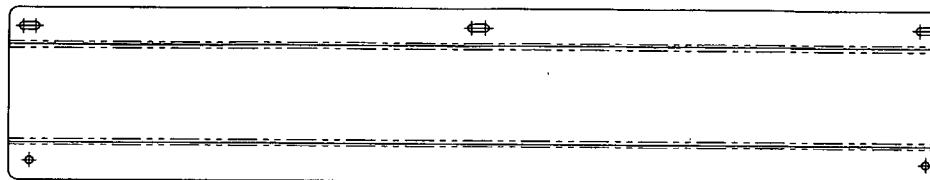
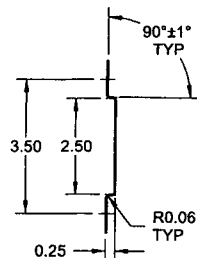
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 58832
BS 10-5-19



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
(MAKE FROM D3641-1F FLAT PATTERN)

RELEASED
2009-11-18

NOTES:

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

| C | REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076 | RF | 09.10.02 |
|------------|---|---|--------------|
| B | UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE | LE | 07.10.16 |
| A | NEW ISSUE; REPLACES G10606 | LE | 07.07.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | TS | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D3641 | SHEET 1 OF 3 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | COVER | NTS |
| DATE | 09.10.02 | <small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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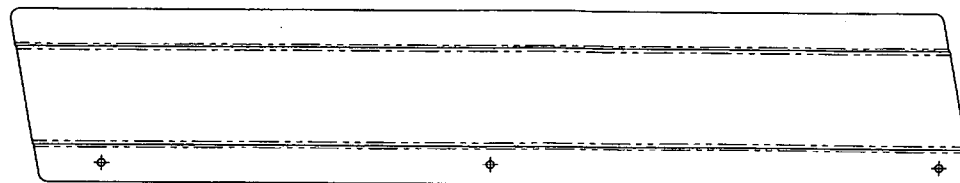
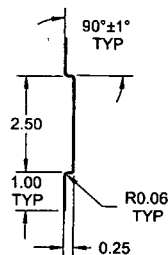
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

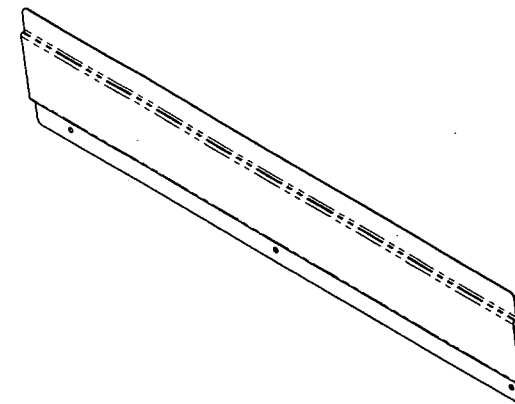
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

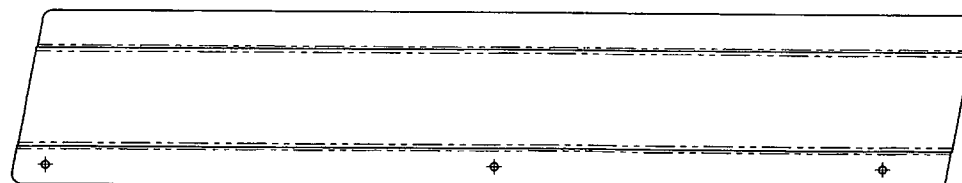
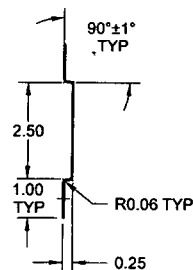


D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
(MAKE FROM D3641-3F FLAT PATTERN)



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)

w/o 58832



D3641-4 COVER
(REPLACES GENEVA P/N G10606-4)
(MAKE FROM D3641-3F FLAT PATTERN)

RELEASED
2009-11-10
WPD

NOTES:

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | TS | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3641 | SHEET 2 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | COVER | NTS |
| DATE | 09.10.02 | <small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

8 7 6 5 4 3 2 1

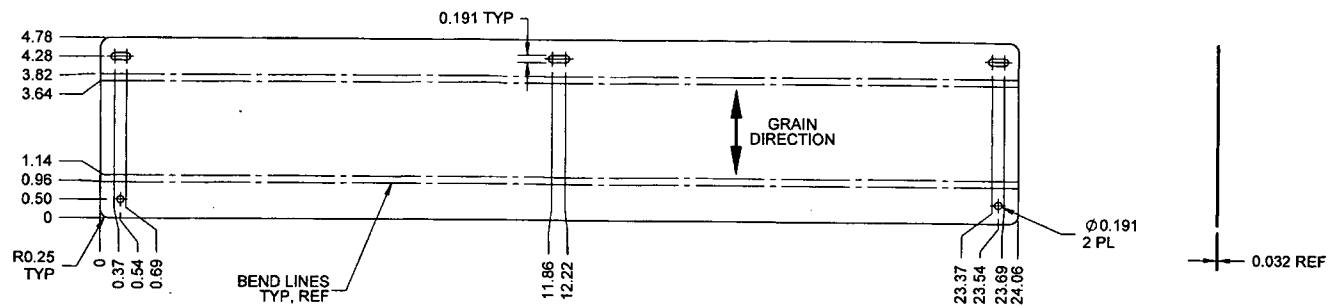
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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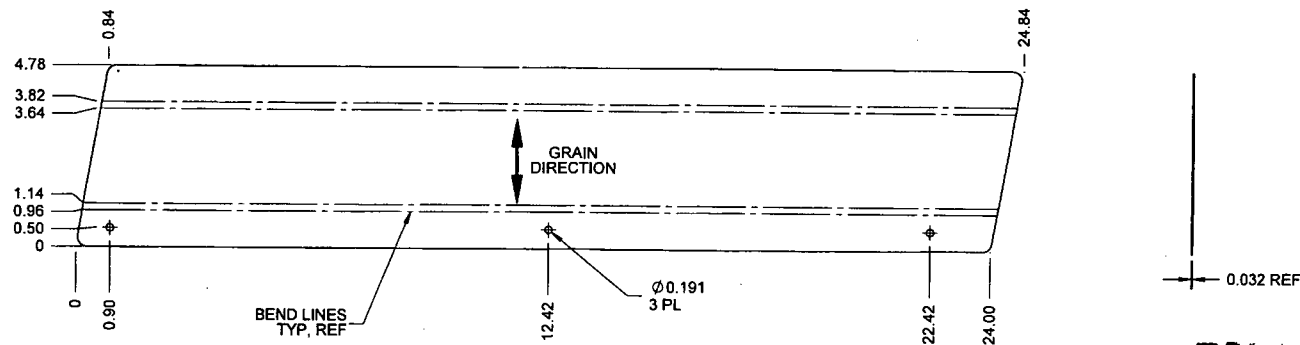
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NOTE: Date & initial all entries



D3641-1F FLAT PATTERN

W0 58832



D3641-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | TS | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3641 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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RELEASED
2009-11-10

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